

Work Order ID 128083

Tuesday, January 06, 2015 9:25:48 AM

128083

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G	DAS 66 9-89							
D3492	C								

100 Document Control 0.00
 100 DOCUMENT CONTROL

DC
 Doc.Control -USB or Paperwork

Memo

record fwd angle: 89.6°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

~~FEB 18 2015~~

~~FEB 20 2015~~

DAS
46
 9-89

15-1-7

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Stop ***NS2***
Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

BB15-01-08

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop*****NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

15-1-13

A4

1 0 15-1-15 De

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Item ID: D350-636-012 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible
Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131126</u> exp. date: 15-10-21 <u>15-10-21</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M30812</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11- Spot face ground handling holes section (total of 4 places per side) as per								

15-1-15 *[Signature]*

[Signature] 15-1-15

BE15-0179

BE15-0120

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

BL-15-01-20

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89
JAN 22 2015

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

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Item ID: D350-636-012 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	Memo	0.00							
Hand Finish	1-Install inserts as per dwg D2750								
Hand Finishing	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11131170</u>								
	EXP DATE: <u>12/02</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11131349</u> RTU 598 1361K 11125792 exp 12/04								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>11127900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	Memo	0.00							
QC									
Quality Control									

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FEB 19 2015

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ DAS Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				1X		DAS 26 9-89	FEB 19 2015
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00				1X		DAS 46 9-89	FEB 20 2015
Quality Control									
270		0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1***Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 1502-23

MF
15-2-20

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	12.0000	1	1			
D2600-3-BENT-RH									**				
Extrusion Bent RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				12					
				125888				12					
D2744		Manufactured	No			110	Each	38.0000	1	1			
D2744									**				
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				38					
				125894				38					
D2739		Manufactured	No			160	Each	13.0000	1	1			
D2739									**				
-3501 Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG003				13					
				125889				13					

15-1-7

1

861501-08

1

DGL 15-1-15.

1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2743 Manufactured No 160 Each 155.0000 8 8

Start Qty: 1.00

Required Qty: 1.00

D2743

Crossbolt Spacer

**

BE15-01-16

Location Loc Qty Loc Code

LG001 155

125893 8

127636 147

D3490-3 Manufactured No 160 Each 107.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE15-01-16

Location Loc Qty Loc Code

LG001 107

125903 107

D3490-1 Manufactured No 160 Each 117.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE15-01-16

Location Loc Qty Loc Code

LG001 117

125902 117

D3631-1 Manufactured No 230 Each 186.0000 8 8

D3631-1

Washer

**

all 12/02/15

Location Loc Qty Loc Code

FP001 186

125912 186

B128320

x 9

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3791-1

Manufactured No

230

Each

38.0000

Start Qty: 1.00
1 1

Required Qty: 1.00

D3791-1

Wearpad

**

all 15/02/09

Location

Loc Qty

Loc Code

FP002

38

B126317

xl

125913

38

D3793-3

Manufactured No

230

Each

40.0000

1

1

D3793-3

Wearplate Aft

**

all 15/02/09

Location

Loc Qty

Loc Code

FP002

40

125915

40

xl

MS21043-6

Purchased No

230

Each

214.0000

4

4

MS21043-6

NUT

**

all 15/02/08

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

194

m130325

6

m130726

188

xl

D3794-1

Manufactured No

230

Each

36.0000

1

1

D3794-1

Gasket Fwd

**

all 15/02/09

Location

Loc Qty

Loc Code

FP001

36

124438

1

125916

35

xl

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-010

Purchased No

230 Each

Start Qty: 1.00
188.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

**

all 1/6/2015

Location

Loc Qty

Loc Code

FP001

188

18131324

X8

m130797

188

D2741

Manufactured No

250 Each

11.0000

**

B125892

D2741

Replacement Blade

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

NAS1515H3L

Purchased No

230 Each

695.0000 4 4

**

all 1/6/2015

***NAS1515H3L ***

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

99

m127831

99

ST266

556

m127831

56

m130726

500

X4

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-013

Purchased

No

230

Each

Start Qty: 1.00
958.0000 8 8

Required Qty: 1.00

NAS1611-013

O-RING

**

ll 15/02/09

Location

Loc Qty

Loc Code

FP001

958

m130758

958

x8

AN3C6A

Purchased

No

230

Each

616.0000 4 4

AN3C6A

Bolt

**

ll 15/02/09

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

126

m128769

126

x4

ST338a

441

m128769

441

NAS1149C0832R

Purchased

No

230

Each

191.0000 1 1

NAS1149C0832R

Washer

**

ll 15/02/09

Location

Loc Qty

Loc Code

FP001

47

m114915

47

x1

ST271

144

m125807

144

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D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3536-25

Manufactured No

230

Each

38.0000

Start Qty: 1.00

Required Qty: 1.00

1

1

D3536-25

Gasket Center

all 15/02/09

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

32

125909

32

B128578

xl

D3794-3

Manufactured No

230

Each

75.0000

1

1

D3794-3

Gasket Aft

all 15/02/09

Location

Loc Qty

Loc Code

FP001

75

124948

1

125917

34

127383

39

92658

1

xl

AN3C5A

Purchased No

230

Each

1,165.000

34

34

AN3C5A

Bolt

all 15/02/09

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

17

M130851

17

ST338a

1143

M130770

1000

M130851

143

X34

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3537-1

Manufactured No

230

Each

67.0000

Start Qty: 1.00

3

3

Required Qty: 1.00

D3537-1

Wearpad

**

all is/ozlog

Location

Loc Qty

Loc Code

FG

18

79833

8

B128225

x3

88562

10

FP001

49

125418

3

126306

46

D3535-25

Manufactured No

230

Each

10.0000

1

1

D3535-25

Wearplate Center

**

all is/ozlog

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

8

125908

8

x1

D3492-3

Manufactured No

230

Each

210.0000

8

8

D3492-3

Plug

**

all is/ozlog

Location

Loc Qty

Loc Code

FP001

210

125905

210

B128476

x2

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Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149C0332R

Purchased

No

230

Each

4,519.000

38

38

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all 12/04/09

Location

Loc Qty

Loc Code

FP001

2657

m130325

2657

11131340

x38

GA

126

125654

126

ST271

1736

m130325

736

m130466

1000

D3488-042

Manufactured

No

230

Each

2.0000

1

1

D3488-042

Blade Fitting RH

**

all 12/02/09

Location

Loc Qty

Loc Code

FP001

2

125901

2

B125900

x1

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

1,622.000

38

38

ALS4-1032-225

Rivnut

**

all 12/02/08

Location

Loc Qty

Loc Code

FG

120

M127028

120

11131582

x38

FP001

698

M131067

698

st549

804

M131067

804

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3492-1

Manufactured No

230

Each

Start Qty: 1.00
189.0000 8 8

Required Qty: 1.00

D3492-1

Plug

**

all 15/02/15

Location

Loc Qty

Loc Code

FP001

189

B129052

125904

189

x8

D3793-1

Manufactured No

230

Each

44.0000

1

1

D3793-1

Wearplate Fwd

**

all 15/02/15

Location

Loc Qty

Loc Code

FP002

44

125914

43

x1

126905

1

AN8C35A

Purchased No

230

Each

27.0000

1

1

AN8C35A

Bolt

**

all 15/02/15

Location

Loc Qty

Loc Code

FG

5

M131367

121275

5

x1

FP001

22

m130114

1

m130784

21

MS21083C8

Purchased No

230

Each

116.0000

1

1

MS21083C8

Nut

**

all 15/02/15

Location

Loc Qty

Loc Code

ST300

116

m131049

116

x1

Picklist Print

Tuesday, January 06, 2015 9:25:51 AM

Page 10

Work Order ID: 128083

128083

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2745

Manufactured No

230

Each

92.0000

Start Qty: 1.00

8 8

Required Qty: 1.00

D2745

Bushing

**

12/02/18

Location

Loc Qty

Loc Code

FP001

92

B128920

x8

125895

92

AN6C44A

Purchased No

230

Each

110.0000

4

4

AN6C44A

Bolt

**

12/02/18

Location

Loc Qty

Loc Code

FG

2

M131367

x1

103964

2

FP001

4

M131546

x3

m130863

4

ST286A

17

m130863

17

ST332

11

m130863

11

ST333

76

m131151

76

D3532-1

Manufactured No

250

Each

32.0000

2

2

D3532-1

Spacer

DAS
46
9-89

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST048

32

125907

32

2x

FEB 19 2015

DAS
26
9-89

Picklist Print

Tuesday, January 06, 2015 9:25:51 AM

Page 11

Work Order ID: 128083

128083

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

MS21083C8

Purchased

No

250

Each

116.0000

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Nut

DAS
46
9-89

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST300

116

m131049

116

2X

NAS1149D0863J

Purchased

No

250

Each

758.0000

2

2

NAS1149D0863J

Washer

DAS
46
9-89

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

700

125268

600

125635

100

st268

1

125268

1

2X

D3493-1

Manufactured

No

250

Each

109.0000

2

2

D3493-1

Washer

DAS
46
9-89

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

99

125906

99

2X

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

FEB 19 2015

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Page 12

Work Order ID: 128083

128083

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

AN8C21A

Purchased

No

250

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

DAS
28
9-89

AN8C21A
Bolt

DAS
46
9-89

**

MTB-1547

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

18

m131100

18

FEB 19 2015

DAS
66
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

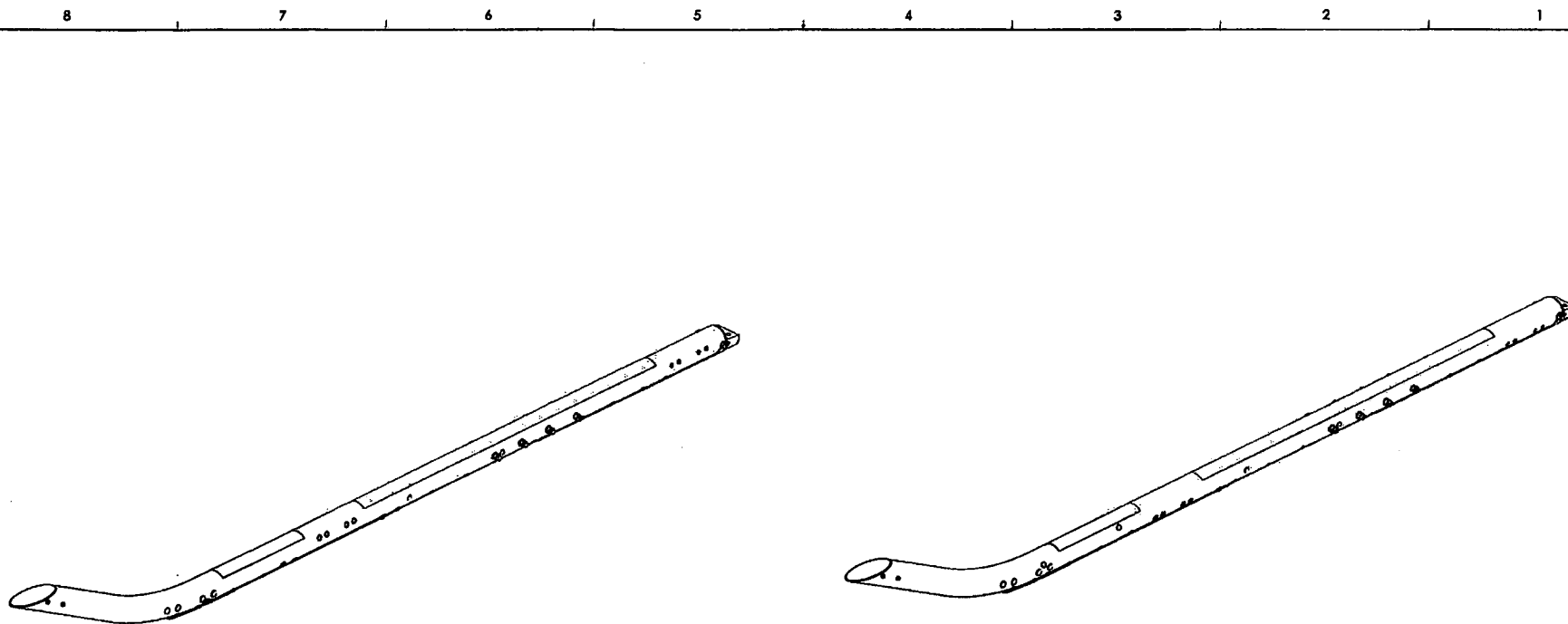
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (6 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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N. 128083 MW
1501-06

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2013-08-13
WD

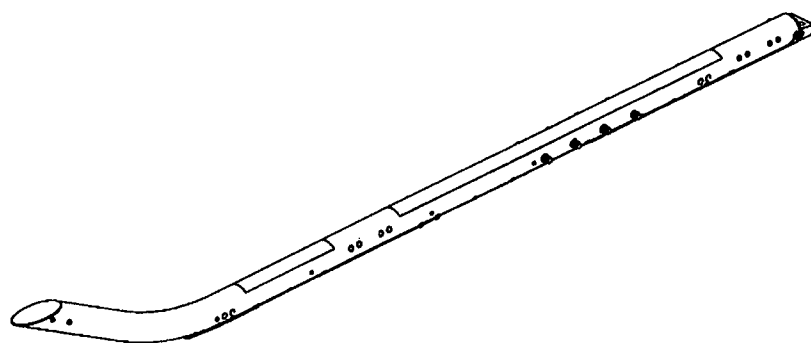


D2750-041 350 SKIDTUBE ASSEMBLY, LH

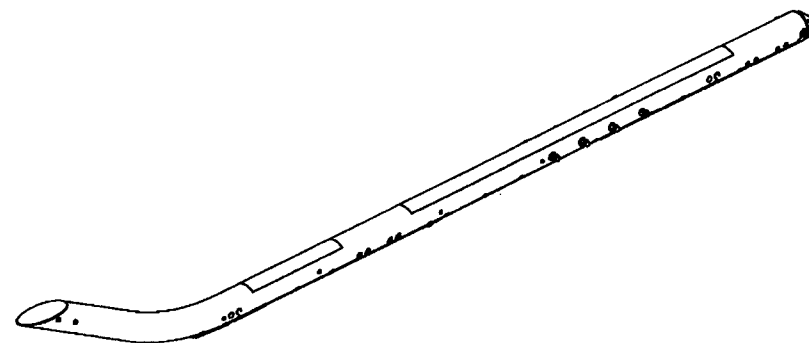
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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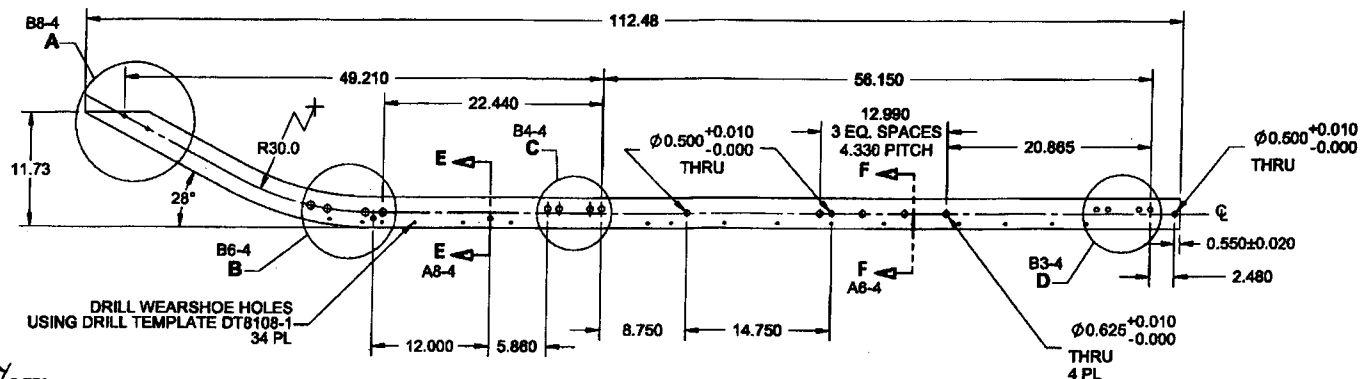
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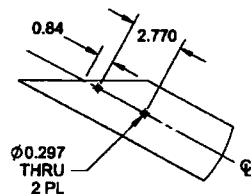
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
wp

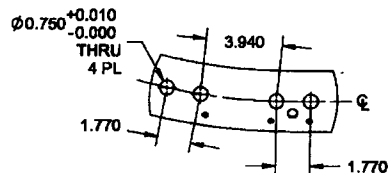
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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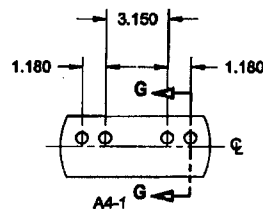
D2750-1 LH SKIDTUBE



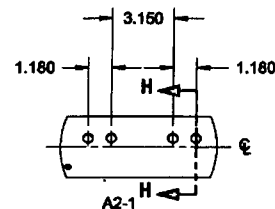
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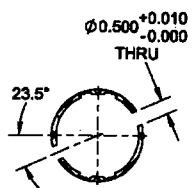
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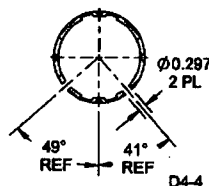
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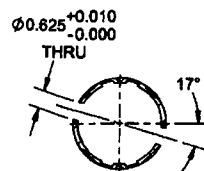
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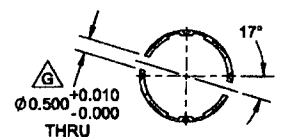
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



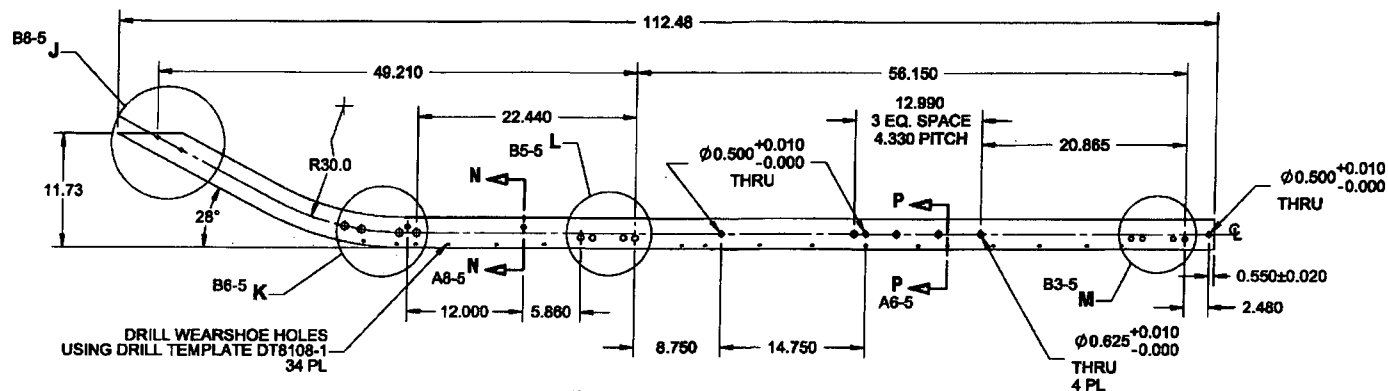
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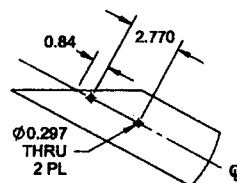
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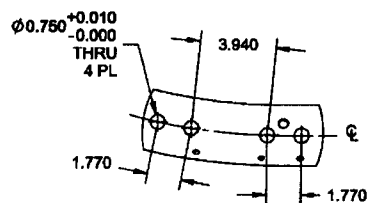
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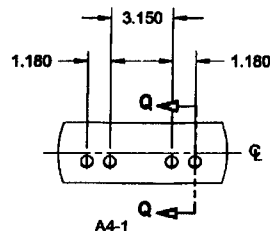
D2750-2 RH SKIDTUBE



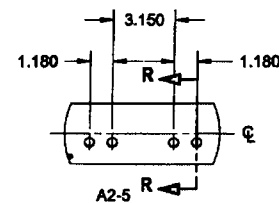
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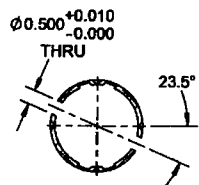
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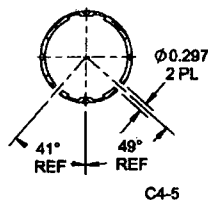
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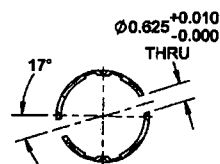
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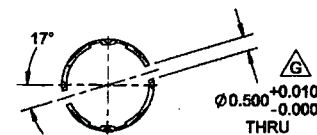
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



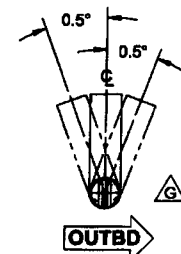
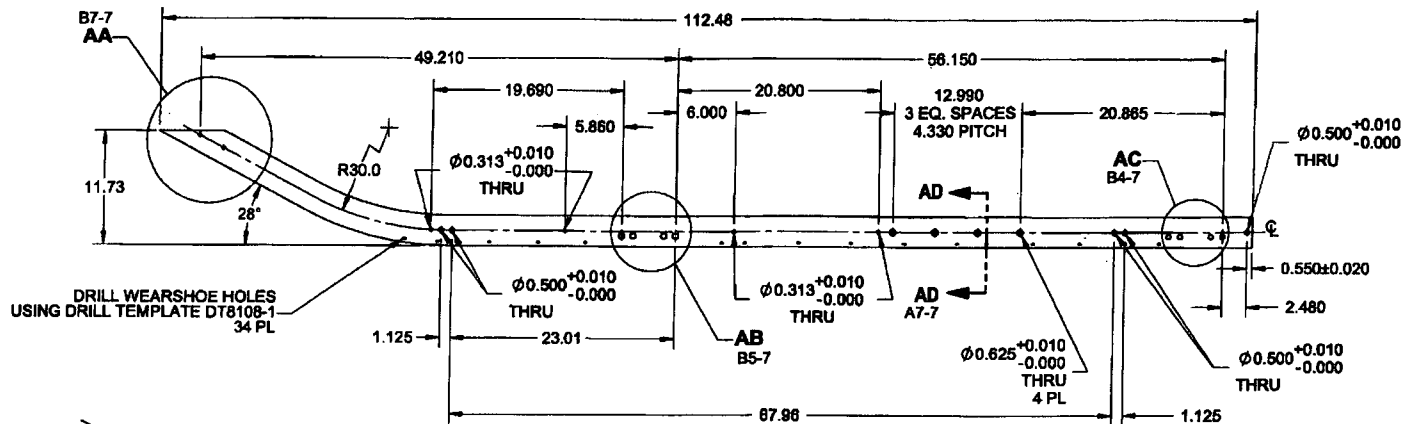
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SCALE 3X, 4 PL



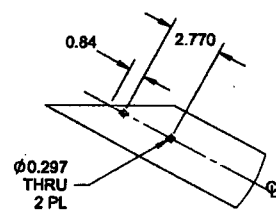
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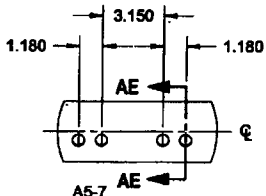
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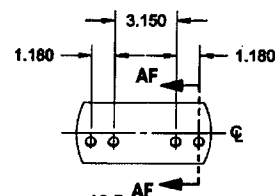
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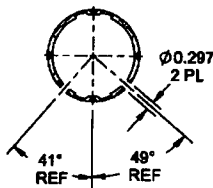
DETAIL AA
D7-7
SCALE 2X



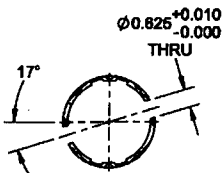
DETAIL AB
C4-7
SCALE 2X



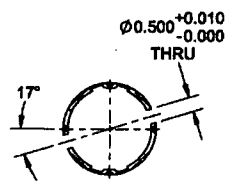
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



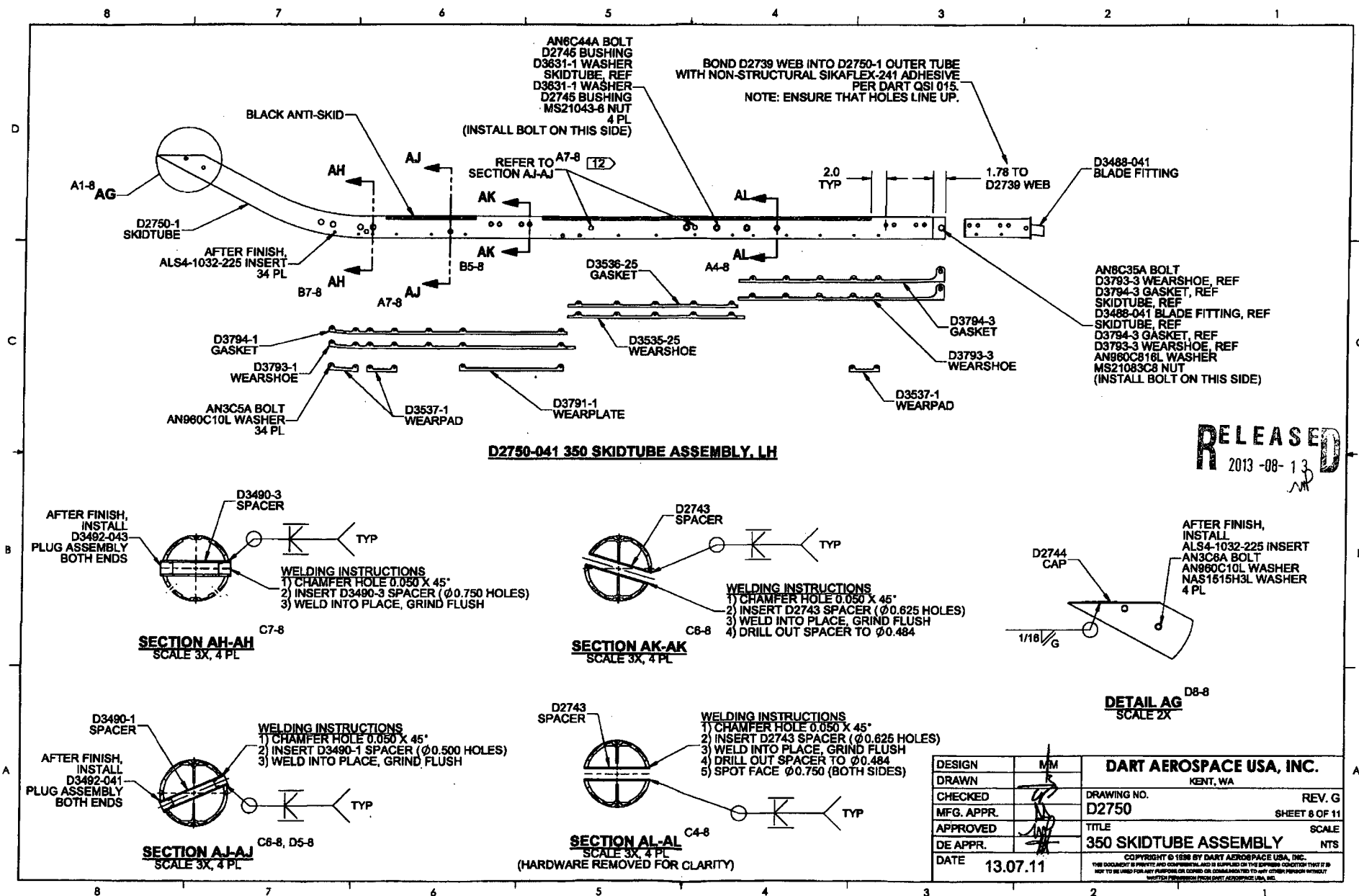
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SCALE 3X, 4 PL



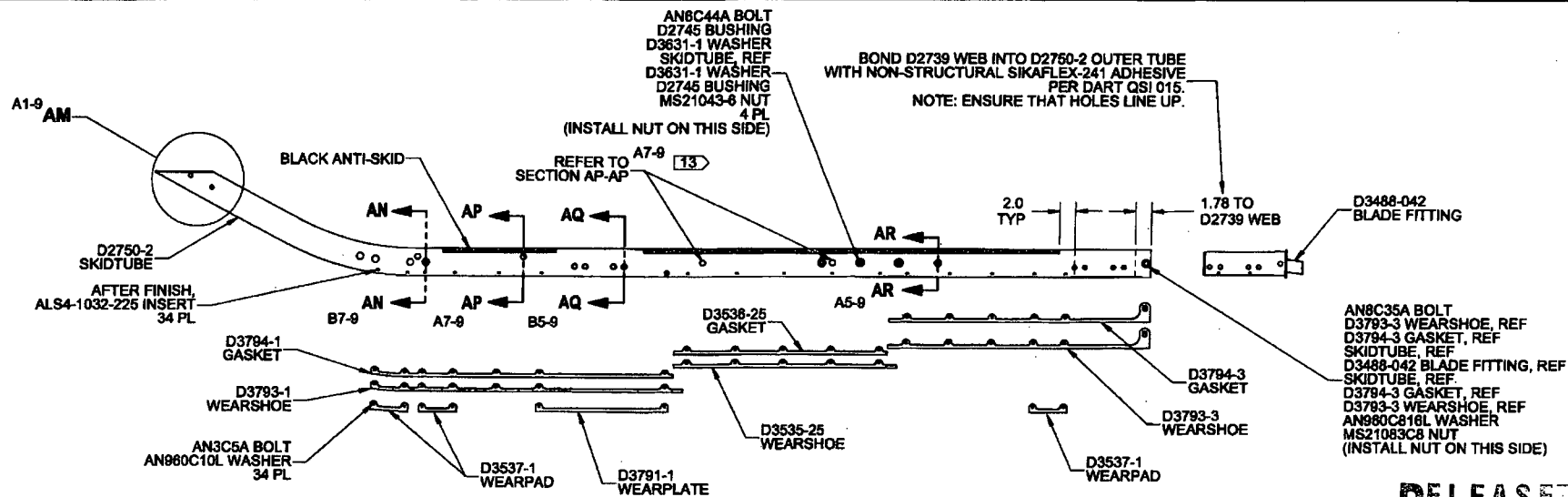
SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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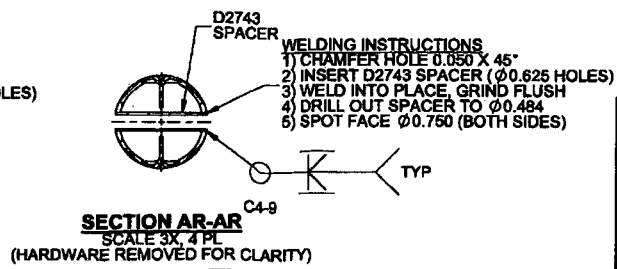
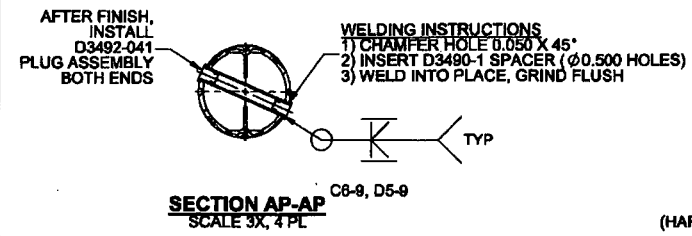
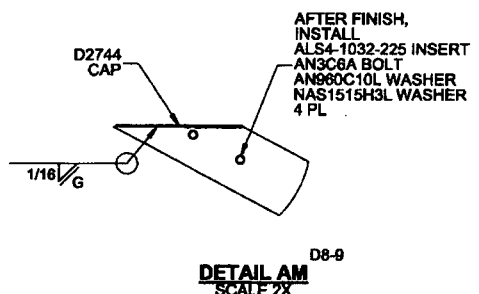
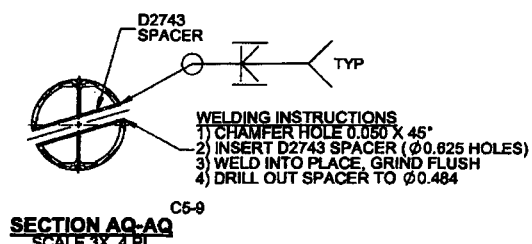
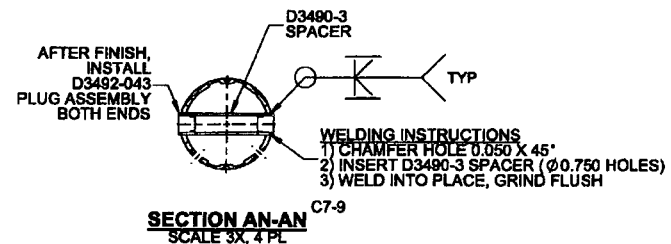


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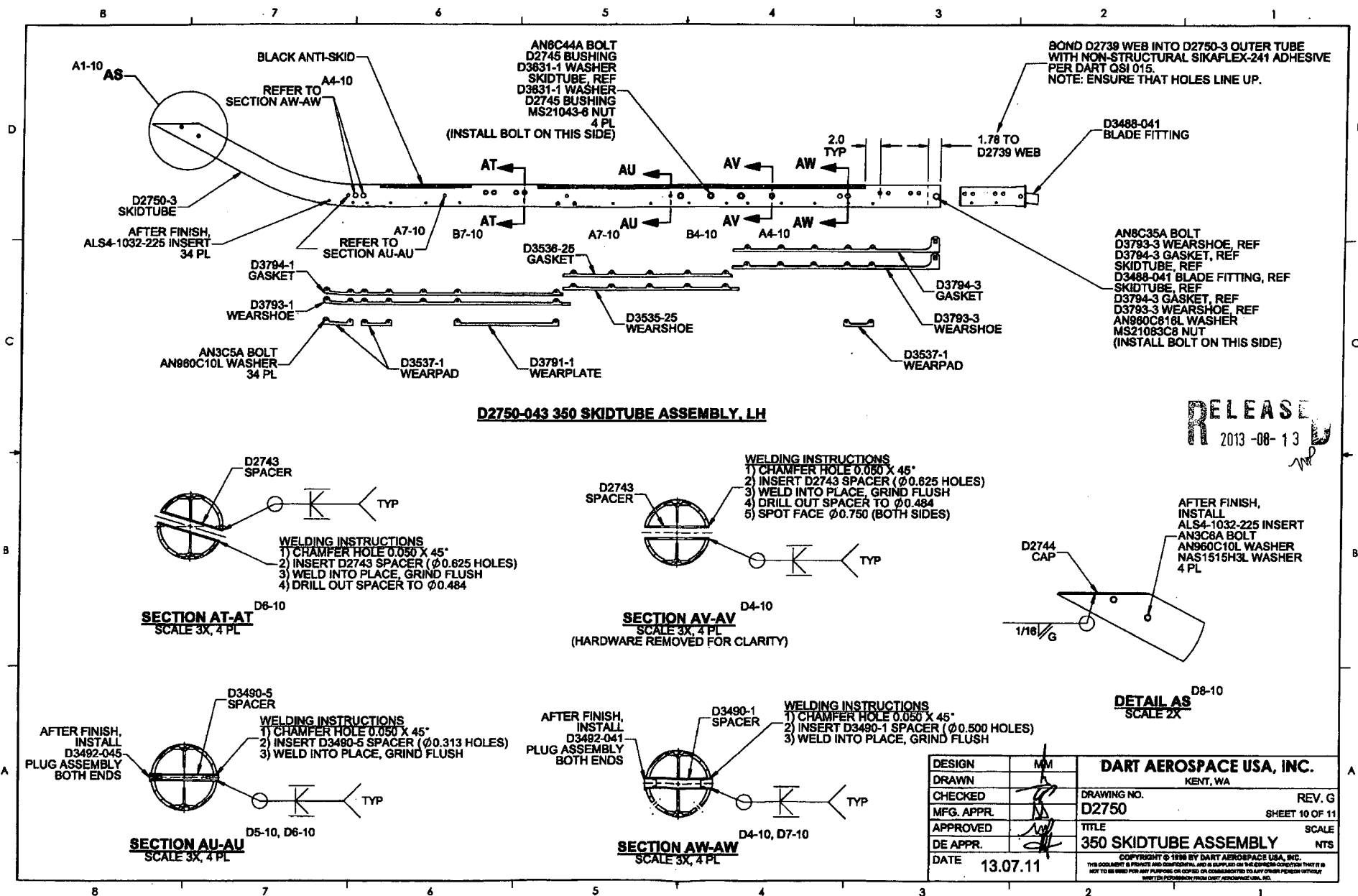
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13

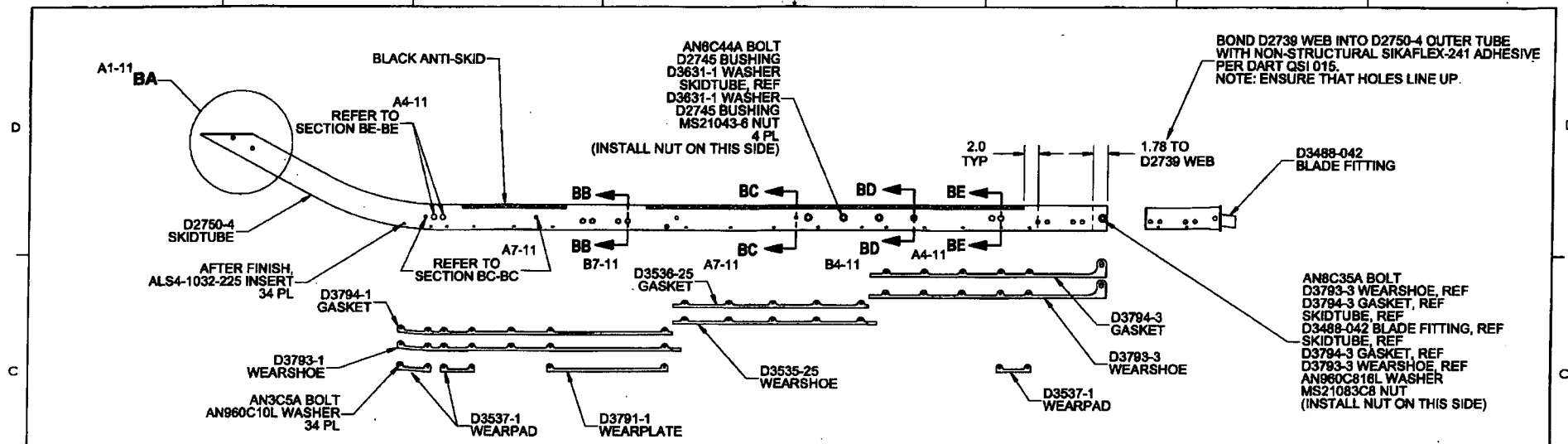


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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1989 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION OF THE SPECIAL COLLECTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

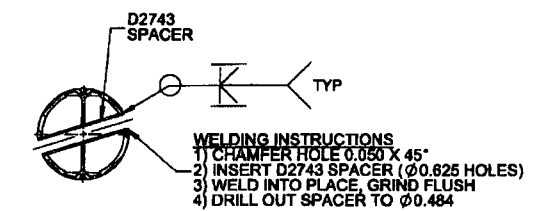
8 7 6 5 4 3 2 1



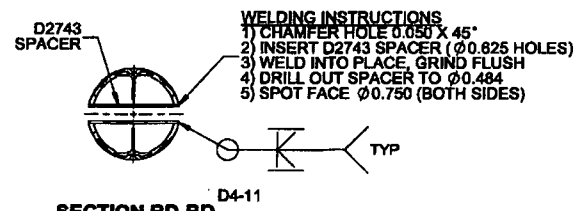
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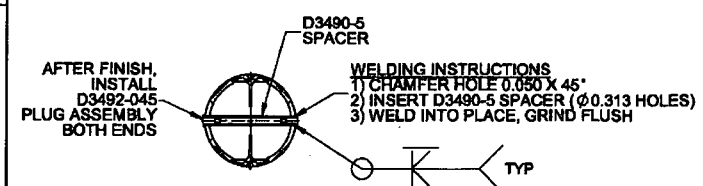
D2750-044 350 SKIDTUBE ASSEMBLY, RH



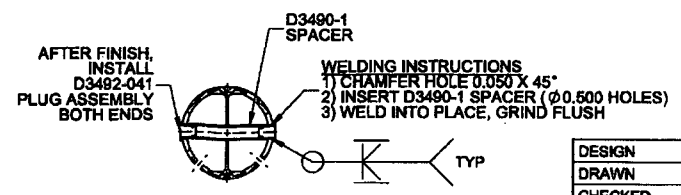
SECTION BB-BB
SCALE 3X, 4 PL



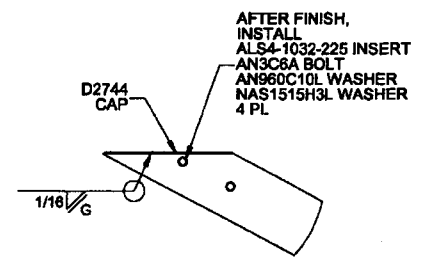
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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